

Tuesday, 11/6/2007 1:38:12 PM  
Kim Johnston

## Process Sheet

Split 071221

Drawing Name : 02.750 SUPPORT  
 Part Number : D28931  
 Drawing Number : D2893 REV B  
 Project Number : N/A  
 Drawing Revision : B  
 Material : N/A  
 Due Date : 12/13/2007 Qty: 20 Um: Each  
 Number : 35579 -2  
 Estimate Number : 10829  
 P.O. Number : N/A  
 This Issue : 11/6/2007 S.O. No. : N/A  
 Prsht Rev. : NC  
 First Issue : N/A Type : MACHINED PARTS  
 Previous Run : 33560  
 Written By :  
 Checked & Approved By :  
 Comment : Est: C 02.11.26 Reformat; Added P/O KJ  
 est D 06.04.19 removed alodine EC  
 Est Rev: E Added priming as per Rev B 07-04-30 JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O: 4996

Description: D6104-005

Material: 17-4 PH SS (AMS 5643 OR AISI 630) as per Dwg D6104

Material release note required.

C 07/11/07

(20)

2.0

D6104005

17-4 SS Roundbar 4.00"OD



Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)  
Support

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive &amp; Inspect for Transit Damage

Ensure Material Release Note is attached

ACME 07/11/07 (20)

C 07/11/07

(20)

4.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

Turn blank for Haas as per Folio FA081

Refer to 11

(19)

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 02.750 SUPPORT

Job Number: 35579

Part Number: D28931

Job Number:



Seq. #	Machine Or Operation:	Description :
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5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

6.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: ~~BAND SAW~~ HAAS  
Machine as per Folio FA081  
Tumble & Deburr

7.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



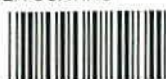
Comment: INSPECT ALL DIM TO DIM SHEET

8.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

9.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING  
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3  
Mask Inside Bore for Priming

10.0	SPRAY PAINTING	SPRAY PAINTING
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Comment: SPRAY PAINTING

Prime inside surface as per Dwg D2893 and QSI 005 4.3.

11.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT

12.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ~~in box~~ cross tube

# Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 02.750 SUPPORT

Job Number: 35579

Part Number: D28931

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



9

Comment: FINAL INSPECTION/W/O RELEASE

88/01/03

Job Completion



2008/1/2  
U



<b>DART AEROSPACE LTD</b>			<b>Work Order:</b>	35579
<b>Description:</b> Ø2.750 Support			<b>Part Number:</b>	D2893-1
<b>Inspection Dwg:</b> D2893 Rev. B			<b>Page 1 of 1</b>	

Inspect dimensions highlighted on inspection sheet drawing D2893 Rev B / DSK078 Rev A and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	17	218	214	4	By	Date
<b>Lathe Section</b>									
A	2.707	2.712		2.711	2.710	2.711			
B	4.946	4.966		4.958	4.956	4.956			
C	3.064	3.084		3.076	3.076	3.076			
D	0.718	0.738		.722	.723	.723			
E	0.090	0.110		.103	.103	.103			
F	2.934	2.954		2.945	2.945	2.945			
G	2.166	2.186		2.170	2.171	2.171			
H	3.890	3.910		3.903	2.903	2.903			
I	0.914	0.934		.930	.930	.930			
J	0.022	0.042		.037	.036	.037			
K	0.109	0.129		.116	.116	.116			
L									
<b>* 1 HAAS Section 19</b>									
AA	2.985	3.005		2.989					
AB	0.440	0.460		.730					
AC	0.125	0.160		.152					
AD	0.040	0.060		.041					
AE	0.188	0.193		.178					
AF	0.125	0.160		.140					
AG	0.140	0.160		.151					
AH	1.360	1.400		1.368					
AI	0.040	0.060		.053					
AJ	1.190	1.230		1.215					
AK	0.010	0.020		.015					
AL	0.053	0.073		.063					
AM	0.240	0.260		.250					
AN	2.518	2.538		2.530					
AO	84.39	90.39		87.39					
AP	0.261	0.266							
AQ	0.053	0.073		.063					
AR									
AS									

Accept/Reject

Measured by:	J. F.
Date:	07/12/21

Audited by:	J. F.
Date:	07/12/21

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	35579
<b>Description:</b> Ø2.750 Support		<b>Part Number:</b>	D2893-1
<b>Inspection Dwg:</b> D2893 Rev. B		<b>Page 1 of 1</b>	

Inspect dimensions highlighted on inspection sheet drawing D2893 Rev B / DSK078 Rev A and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				13	14	15	16		
<b>Lathe Section</b>									
A	2.707	2.712	2.711	2.712	2.710	2.711	2.710		
B	4.946	4.966	4.952	4.955	4.958	4.956	4.956		
C	3.064	3.084	3.073	3.075	3.075	3.075	3.075		
D	0.718	0.738	.723	.723	.723	.713	.723		
E	0.090	0.110	.103	.103	.103	.103	.103		
F	2.934	2.954	2.945	2.945	2.945	2.945	2.945		
G	2.166	2.186	2.172	2.172	2.177	2.177	2.177		
H	3.890	3.910	3.902	3.902	3.902	3.902	3.902		
I	0.914	0.934	.930	.930	.930	.930	.930		
J	0.022	0.042	.030	.030	.030	.030	.030		
K	0.109	0.129	.117	.117	.117	.117	.117		
L									
<b>HAAS Section</b>									
AA	2.985	3.005							
AB	0.440	0.460							
AC	0.125	0.160							
AD	0.040	0.060							
AE	0.188	0.193							
AF	0.125	0.160							
AG	0.140	0.160							
AH	1.360	1.400							
AI	0.040	0.060							
AJ	1.190	1.230							
AK	0.010	0.020							
AL	0.053	0.073							
AM	0.240	0.260							
AN	2.518	2.538							
AO	84.39	90.39							
AP	0.261	0.266							
AQ	0.053	0.073							
AR									
AS									
<b>Accept/Reject</b>									

Measured by:	<i>[Signature]</i>
Date:	

Audited by:	
Date:	

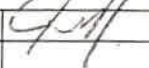
Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	<i>[Signature]</i>





<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	35579
<b>Description:</b> Ø2.750 Support		<b>Part Number:</b>	D2893-1
<b>Inspection Dwg:</b> D2893 Rev. B		<b>Page 1 of 1</b>	

Inspect dimensions highlighted on inspection sheet drawing D2893 Rev B / DSK078 Rev A and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	19	210	11	12	By	Date
<b>Lathe Section</b>									
A	2.707	2.712		2.710	2.710	2.710	2.710		
B	4.946	4.966		4.953	4.953	4.953	4.953		
C	3.064	3.084		3.025	3.048	3.048	3.075		
D	0.718	0.738		.722	.722	.722	.722		
E	0.090	0.110		.103	.103	.103	.103		
F	2.934	2.954		2.945	2.945	2.945	2.945		
G	2.166	2.186		2.172	2.172	2.172	2.172		
H	3.890	3.910		3.902	3.902	3.902	3.902		
I	0.914	0.934		.930	.930	.930	.930		
J	0.022	0.042		.032	.032	.032	.032		
K	0.109	0.129		.116	.116	.116	.116		
L									
<b>HAAS Section</b>									
AA	2.985	3.005							
AB	0.440	0.460							
AC	0.125	0.160							
AD	0.040	0.060							
AE	0.188	0.193							
AF	0.125	0.160							
AG	0.140	0.160							
AH	1.360	1.400							
AI	0.040	0.060							
AJ	1.190	1.230							
AK	0.010	0.020							
AL	0.053	0.073							
AM	0.240	0.260							
AN	2.518	2.538							
AO	84.39	90.39							
AP	0.261	0.266							
AQ	0.053	0.073							
AR									
AS									
<b>Accept/Reject</b>									

Measured by:	
Date:	

Audited by:	
Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM 	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 35579
<b>Description:</b> Ø2.750 Support	<b>Part Number:</b> D2893-1
<b>Inspection Dwg:</b> D2893 Rev. B	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2893 Rev B / DSK078 Rev A and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
Lathe Section									
A	2.707	2.712		2.710	2.7115	2.710	2.710		
B	4.946	4.966		4.960	4.966	11	4.956		
C	3.064	3.084		3.075	3.075	3.075	3.075		
D	0.718	0.738		.722	.722	.722	.722		
E	0.090	0.110		.103	.103	.103	.103		
F	2.934	2.954		2.945	2.945	2.945	2.945		
G	2.166	2.186		2.172	2.172	2.172	2.172		
H	3.890	3.910		3.902	3.902	3.902	3.902		
I	0.914	0.934		.930	.930	.930	.930		
J	0.022	0.042		.032	.032	.032	.032		
K	0.109	0.129		.116	.116	.116	.116		
L									
* 17 HAAS Section 3 4									
AA	2.985	3.005		2.990	2.988	2.990	2.988		
AB	0.440	0.460		.450	.450	.450	.450		
AC	0.125	0.160		.140	.154	.142	.147		
AD	0.040	0.060		.044	.044	.044	.044		
AE	0.188	0.193		.188	.188	.188	.188		
AF	0.125	0.160		.138	.137	.139	.138		
AG	0.140	0.160		.151	.152	.150	.151		
AH	1.360	1.400		1.363	1.369	1.371	1.371		
AI	0.040	0.060		.054	.050	.051	.051		
AJ	1.190	1.230		1.212	1.215	1.217	1.218		
AK	0.010	0.020		.015	.015	.015	.015		
AL	0.053	0.073		.063	.063	.063	.063		
AM	0.240	0.260		.250	.250	.250	.250		
AN	2.518	2.538		2.530	2.530	2.530	2.530		
AO	84.39	90.39		87.39	87.39	87.39	87.39		
AP	0.261	0.266		.261	.260	.260	.260		
AQ	0.053	0.073		.063	.063	.063	.063		
AR									
AS									
Accept/Reject									

Measured by: <i>[Signature]</i>
Date: 07.12.14

Audited by: <i>[Signature]</i>
Date: 11.2.15

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>



<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 35579
<b>Description:</b> Ø2.750 Support	<b>Part Number:</b> D2893-1
<b>Inspection Dwg:</b> D2893 Rev. B	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2893 Rev B / DSK078 Rev A and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				5	26	7	43		
<b>Lathe Section</b>									
A	2.707	2.712	2.711	2.711	2.709	2.708	2.710		
B	4.946	4.966	4.957	4.957	4.956	4.956	4.954		
C	3.064	3.084	3.076	3.076	3.076	3.076	3.065		
D	0.718	0.738	.722	.722	.722	.722	.722		
E	0.090	0.110	.103	.103	.103	.103	.103		
F	2.934	2.954	2.945	2.945	2.945	2.945	2.945		
G	2.166	2.186	2.172	2.172	2.172	2.172	2.172		
H	3.890	3.910	3.903	3.903	3.901	3.901	3.901		
I	0.914	0.934	.930	.930	.930	.930	.930		
J	0.022	0.042	.037	.037	.037	.037	.037		
K	0.109	0.129	.116	.116	.116	.116	.116		
L									
<b>SHAAS Section</b>									
AA	2.985	3.005							
AB	0.440	0.460							
AC	0.125	0.160							
AD	0.040	0.060							
AE	0.188	0.193							
AF	0.125	0.160							
AG	0.140	0.160							
AH	1.360	1.400							
AI	0.040	0.060							
AJ	1.190	1.230							
AK	0.010	0.020							
AL	0.053	0.073							
AM	0.240	0.260							
AN	2.518	2.538							
AO	84.39	90.39							
AP	0.261	0.266							
AQ	0.053	0.073							
AR									
AS									

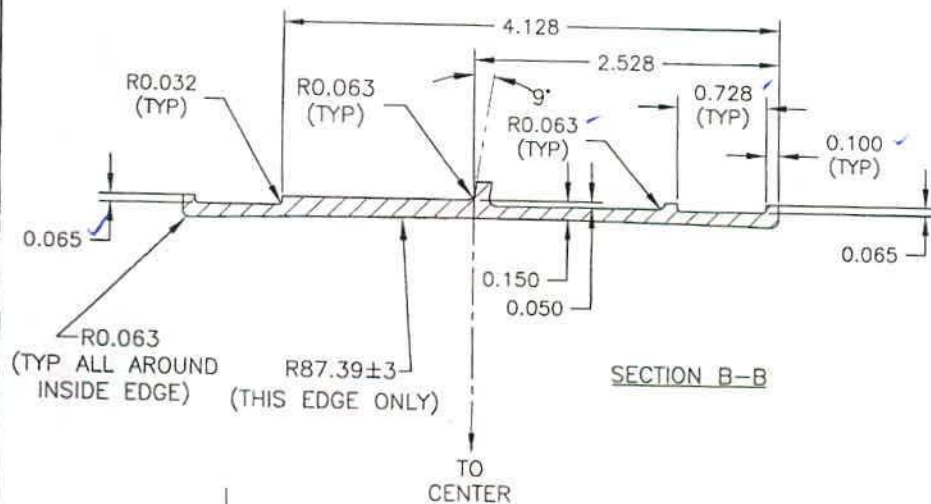
Accept/Reject

Measured by:	
Date:	

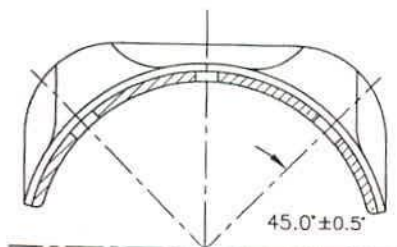
Audited by:	
Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	

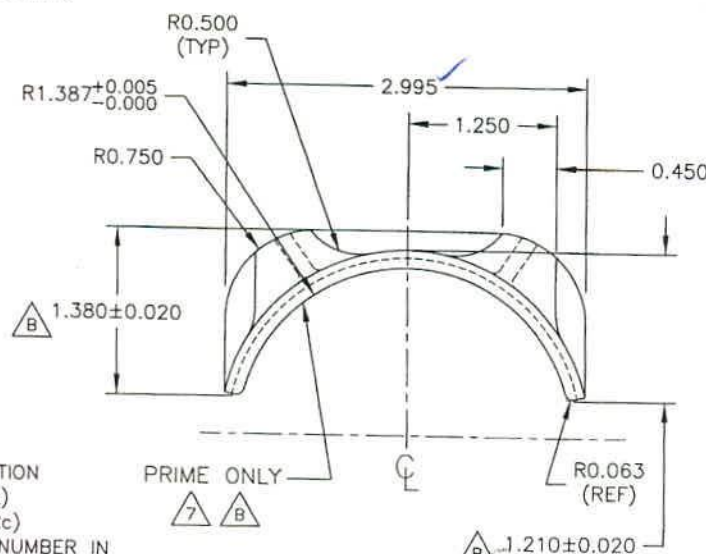




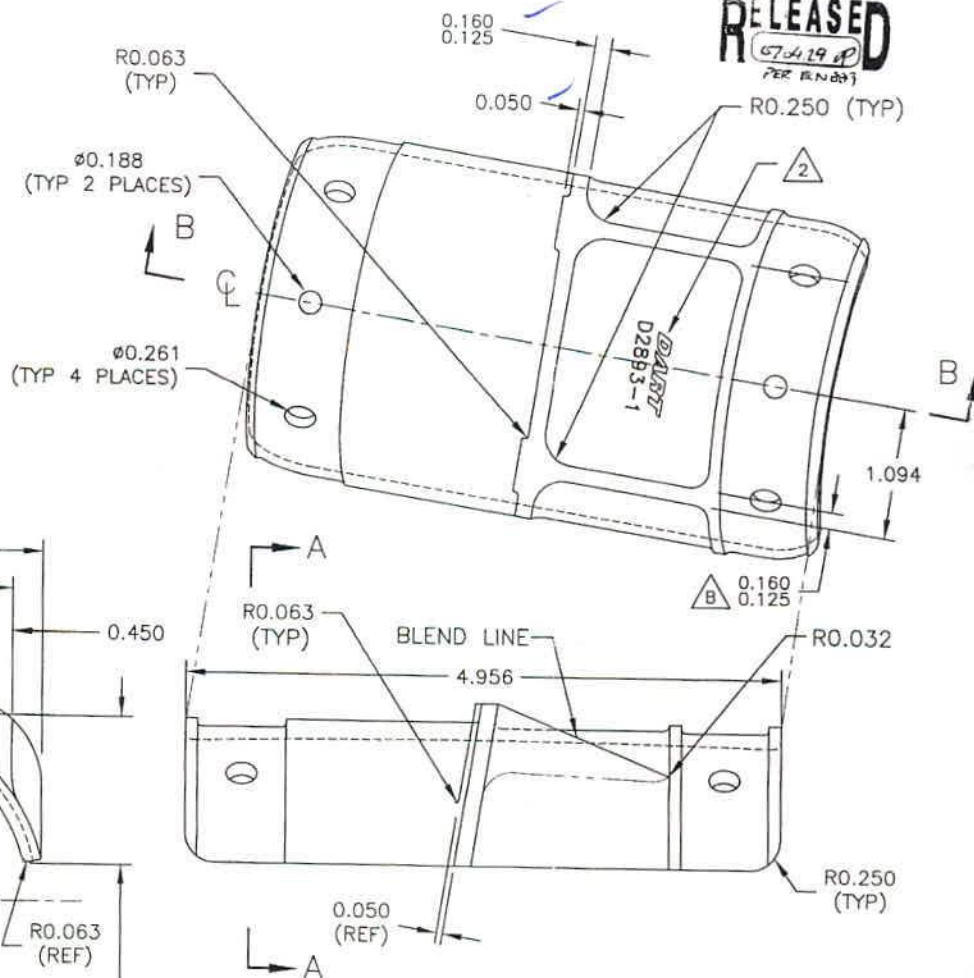
SECTION B-B



SECTION A-A  
TOOLING HOLE DETAIL



PRIME ONLY  
B 7



RELEASED  
57419 P  
PER IN 803

D2893-1

- 1) MATERIAL: 17-4 PH STAINLESS STEEL  
HEAT TREAT TO H900 CONDITION  
(900°F FOR 1 HR, AIR COOL)  
MIN UTS = 170 KSI (38 HRC)
- 2) IDENTIFY WITH DART LOGO AND PART NUMBER IN  
THIS AREA WITH 0.125 HIGH LETTERING 0.010-0.020 DEEP
- 3) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3  
PRIME INSIDE SURFACE AS SHOWN PER DART QSI 005 4.2

NO. 35579

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PERSON WITHOUT WRITTEN PERMISSION FROM  
DART AEROSPACE LTD.

B	07.03.16	UPDATE DIMS AS MFG., PRIME INSIDE
A	01.01.10	NEW ISSUE
DESIGN	q2	DRAWN BY PH
CHECKED	#	APPROVED
DATE	07.03.16	TITLE
		D2893
		02.750 SUPPORT

**DART** DART AEROSPACE LTD.  
MARKHAM, ONTARIO, CANADA

REV. B  
SHEET 1 OF 1  
SCALE  
1:1